

Date: Wednesday, 1/24/2007 4:48:33 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L AFT X-TUBE
Job Number	: 30434		
Estimate Number	: 10973		
P.O. Number	: <i>N/A</i>	Part Number	: D206667203
This Issue	: 1/24/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D206-667-243 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 30433	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

*[Signature]* *KS 07.02.07*

2.0	D6004115	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube *325664*

Check OD = 2.500"; ID = 1.800"

*[Signature]* *07/02/09*

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

*[Signature]* *07/02/09*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*[Signature]* *07/02/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:48:34 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

*ml 07/02/10*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*ml 07/02/10*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 07/03/10*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

*JD 7-3-19*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JD 7-3-19*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JD 7-3-19*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

*EL 7-5-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: 206L AFT X-TUBE

Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*Handwritten signature and date: 07-05-16*

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.
- 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243  
Check dimensions between holes on all four sides.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.
- 5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
- 6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.
- 8-C'sink holes as per Dwg D206-667-243.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

*Handwritten: 7-6-11*

*Handwritten: JD 7-6-11*

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten: JD 7-6-11*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten: 7-06-12*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten: 7-06-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3960 C207106/12 0

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

19.0 QC6 DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20.0 D2873045 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 29852

27 07 06-14

21.0 D2873043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 30449

27 07 06-14

22.0 MS20601AD4W10 RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 103395

27 07-06-14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L AFT X-TUBE

Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07-06-13

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

RT 07-06-13

3-Paint outside crosstube with White Imron as per QSI 005 4.2

25.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

30822

RT 07-06-14

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

101772 28078

RT 07-06-14

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

101772

RT 07-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

} 25  
02 05-18

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-140

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102850 - ✓

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M102536 - ✓

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

10 AN5-10A

Description Batch

Bolt

M102404 - ✓

7/6/15 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/06/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 30434

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M10215 X

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M103641 X

7/6/1589

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/6/150

C27106115 ①

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

C

7/6/15

① 50

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/6/15

Job Completion



U 07-16-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 30434
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> D206-667-243
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

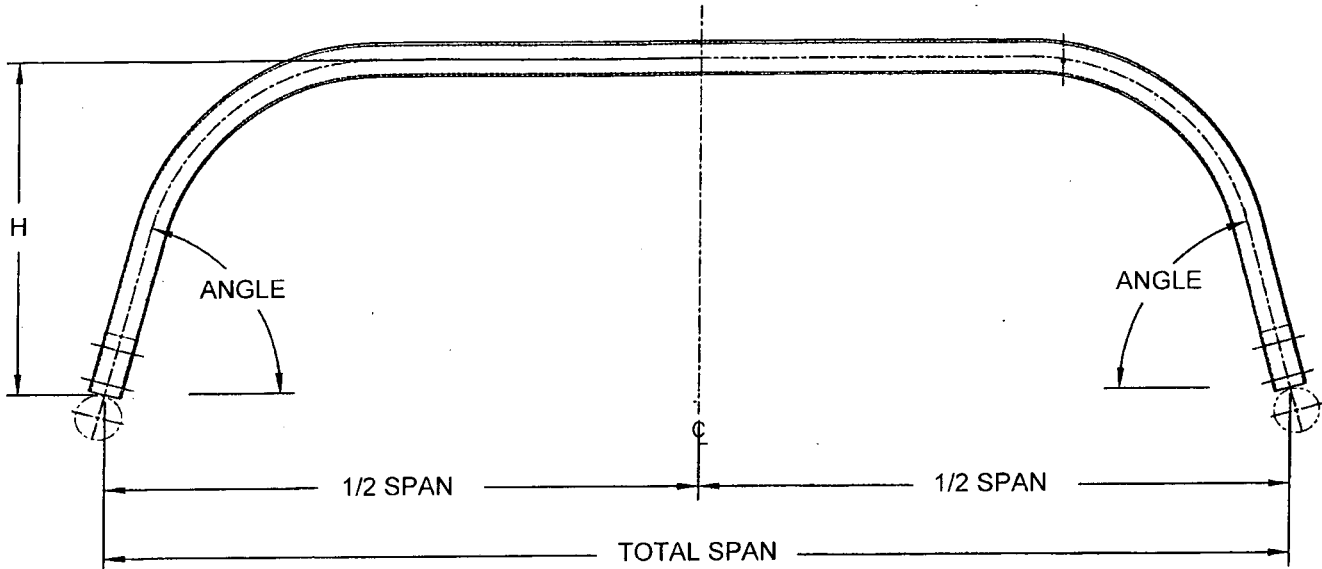
☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.490	—		
	2.018	+0.005/-0.000	2.021	—		
	2.079	+0.005/-0.000	2.083	—		
	2.145	+0.005/-0.000	2.149	—		
	2.209	+0.005/-0.000	2.213	—		
	2.287	+0.005/-0.000	2.290	—		
	2.363	+0.005/-0.000	2.365	—		
	2.433	+0.005/-0.000	2.436	—		
	0.200	+/-0.010	0.207	—		
	0.500 x 30°	+/-0.010	0.500x30°	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.438	+/-0.030	4.438	—		
	104.91	+/-0.020				
	2.490	+0.005/-0.000	2.496	—		
SIDE B	2.018	+0.005/-0.000	2.021	—		
	2.079	+0.005/-0.000	2.084	—		
	2.145	+0.005/-0.000	2.150	—		
	2.209	+0.005/-0.000	2.214	—		
	2.287	+0.005/-0.000	2.290	—		
	2.363	+0.005/-0.000	2.365	—		
	2.433	+0.005/-0.000	2.437	—		
	0.200	+/-0.010	0.207	—		
	0.500 x 30°	+/-0.010	0.500x30°	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.438	+/-0.030	4.438	—		
	104.91	+/-0.020				
	2.490	+0.005/-0.000	2.496	—		
	2.018	+0.005/-0.000	2.021	—		
	2.079	+0.005/-0.000	2.084	—		

<b>Measured by:</b> JML	<b>Audited by:</b> SE	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/02/10	<b>Date:</b> 07-02-15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

# Crosstube Bend Dimension Sheet



PART NUMBER: \_\_\_\_\_

BATCH NUMBER: 30434

DRAWING: \_\_\_\_\_ REVISION: \_\_\_\_\_

H: \_\_\_\_\_

1/2 SPAN: \_\_\_\_\_

TOTAL SPAN: \_\_\_\_\_

ANGLE: \_\_\_\_\_

QC 15: \_\_\_\_\_

DATE: \_\_\_\_\_

QTY: \_\_\_\_\_





DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

05.07.26 - #

**UNDER REVIEW**  
06.08.10 RH  
re draw detail F  
PH  
07.01.15

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

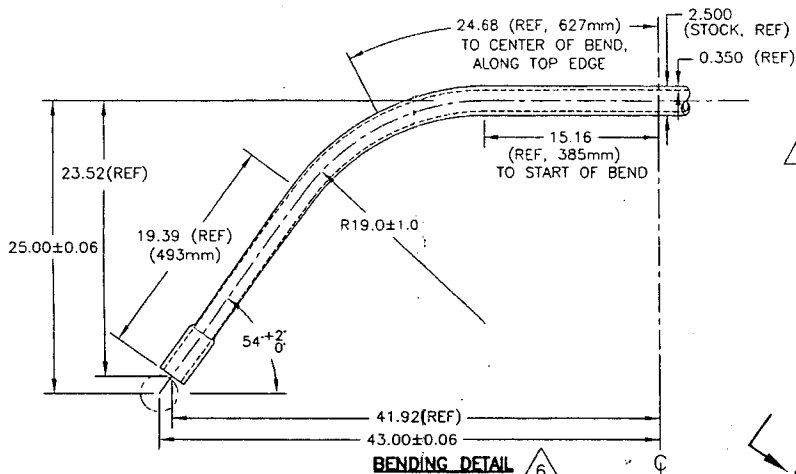
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

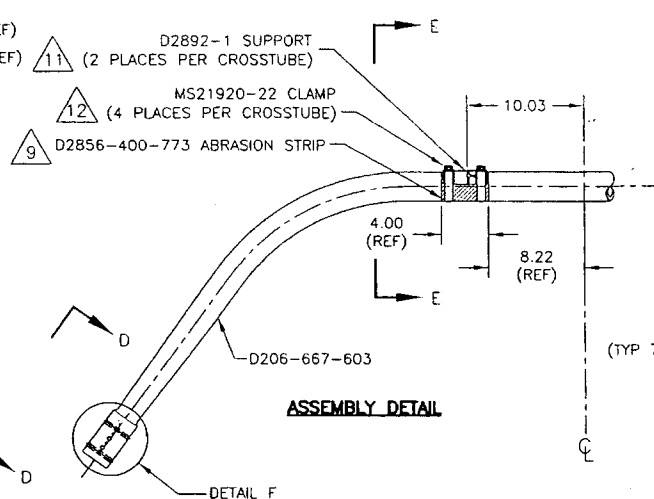
SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30434

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**BENDING DETAIL 6**



**ASSEMBLY DETAIL**

△ B  $\emptyset 0.323 \pm 0.005$   
 (TYP 5 PLACES PER CUFF)  
 HOLE TO BE ALIGNED WITHIN  $\pm 0.001$   
 OF HOLE ON OTHER SIDE OF CUFF

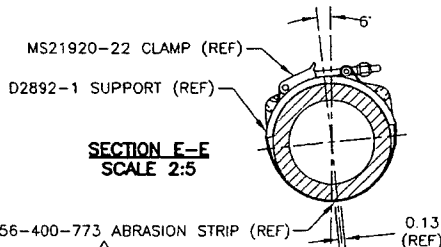
PILOT  $\emptyset 0.128$   
 C'SINK  $\emptyset 0.225 \times 1.00$   
 (TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

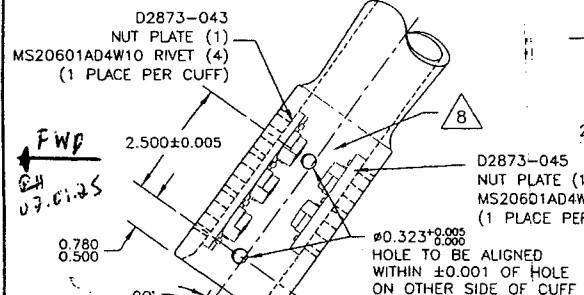
**DETAIL F  
SCALE 2:5**

**UNDER REVIEW**  
 DR. D. J. C. PH  
 re-draw detail F

FWD SIDE ONLY  
 PH  
 07.01.25

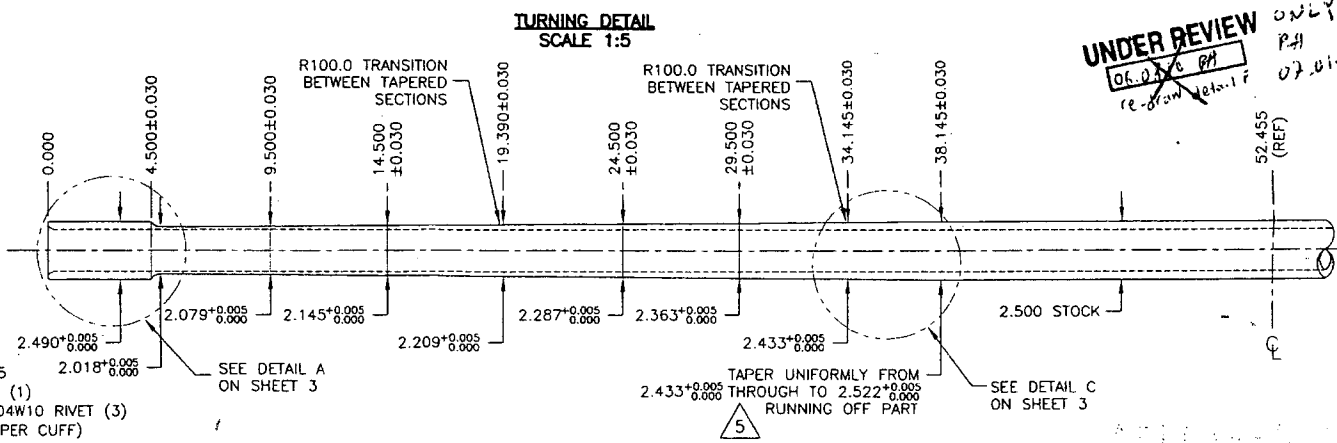


**SECTION E-E  
SCALE 2:5**



**VIEW D-D:  
CUFF DETAIL  
SCALE 2:5**

NO. 350434  
 WORK ORDER  
 WITHOUT NOTICE  
 CONTROLLED COPY  
 RETURN TO  
 ENGINEERING  
 SHOT COPY

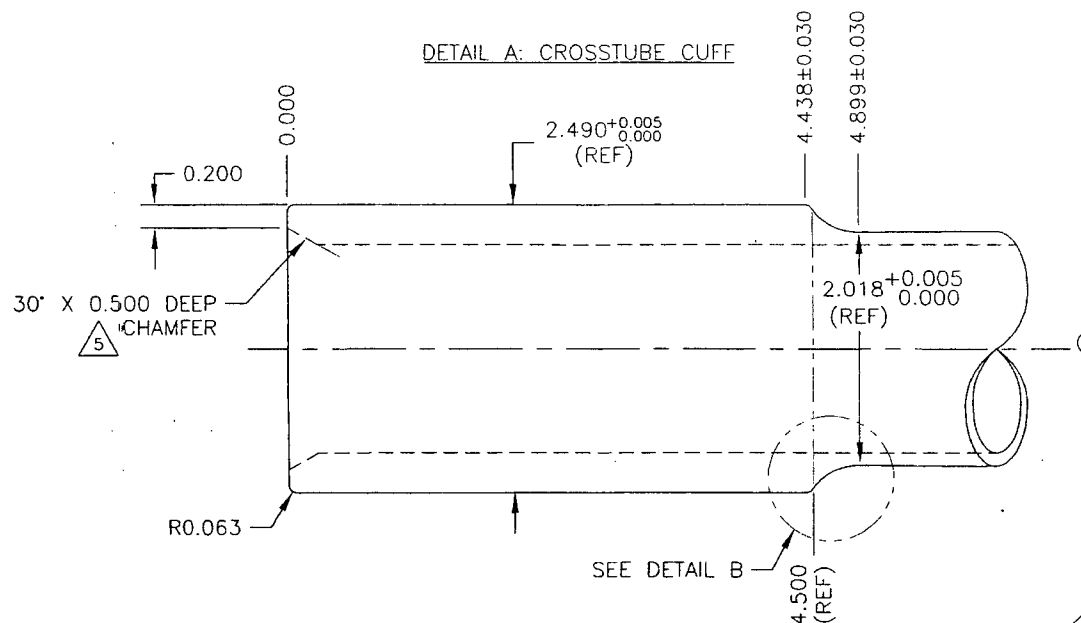


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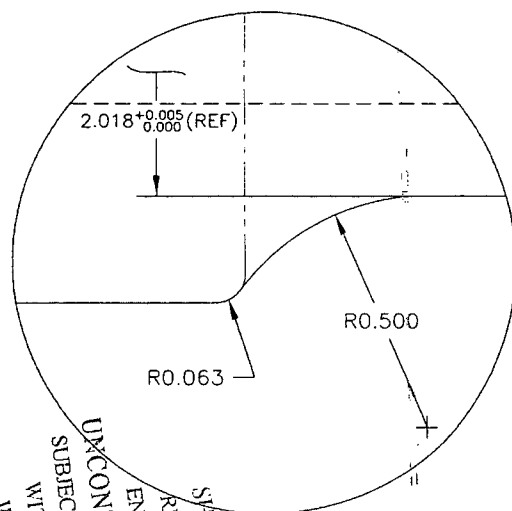
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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	REV. B
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-243	SHEET 2 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:10	

# DETAIL A: CROSSTUBE CUFF

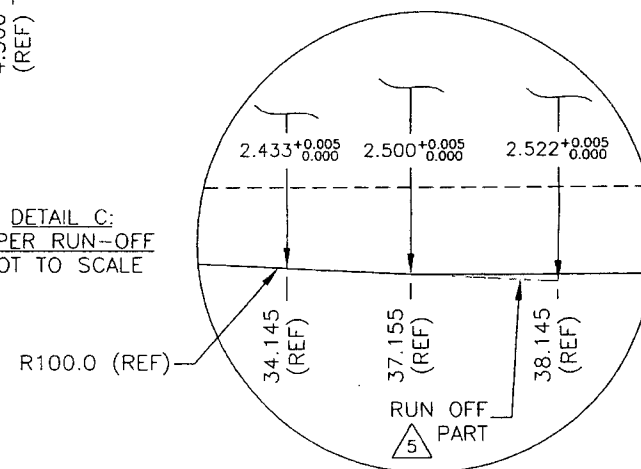


05.07.26 #  
**UNDER REVIEW**  
~~06.08.10 PH~~  
re-drawn detail F  
PH  
07.01.25



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



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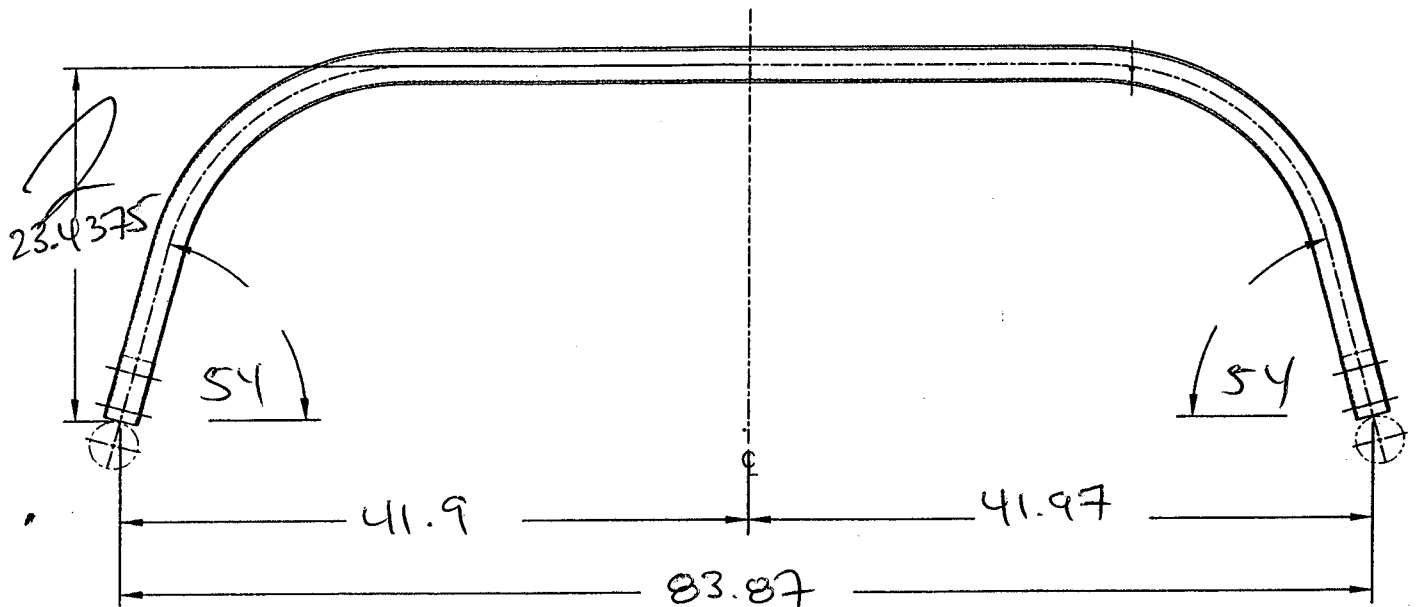
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DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. WARRICKS, ONTARIO, CANADA
PH	PH		
CHECKED #DS	APPROVED #DS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1

NO. 30434  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DART AEROSPACE LTD		Work Order: 30434
Description: Crosstube High Aft (206L)		Part Number: D206-667-203
Inspection Dwg: D206-667-243      Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	<i>[Signature]</i>
Date	07.05.16

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3

Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36657

A.M.O. Number: 46/90

**NON-DESTRUCTIVE TESTING REPORT****AIRCRAFT/COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

**INSPECTION REQUIREMENTS**

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D206-667-203 S/N's B30434 &amp; B30433

Qty. (2) P/N D206-667-103 S/N's B32139 &amp; B32138

Qty. (1) P/N D412-664-245 S/N B32211

Qty. (1) P/N D212-664-201 S/N B32151

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDDY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

  
S. FLETCHER

DATE June 13, 2007

INSPECTION STAMP(S) Not Required

**CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER

ADDRESS:

CONTACT NAME:

LABOUR

MATERIALS

TRAVEL EXPENSES

HOTEL EXPENSES

\$

GST

PST

INVOICE NO.

TOTAL \$

## CUSTOMER RETURN

Initiator: Joan Kerr  
 Company: Trans North Helicopters  
CTRAN03  
 Phone No. 867-668-2177

Date: June 19/07  
 Invoice # 4311  
 Order Entry # 3823

Attach Copy of DHS Return Authorization # 266

Reason for return: Customer Cancelled order

Return to Stock.

## Receiving:

Date Received: 8/1/18 Freight Company: Levic 437-25 0586 Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-667-203	30434	Aft X tube	<u>DAVE</u>	<u>8/1/18</u>
1	D206-667-103	32139	Fwd X tube		

Condition of packaging: \_\_\_\_\_ Photograph required: yes no

Paperwork attached: P/S \_\_\_\_\_ Invoice \_\_\_\_\_ ARC \_\_\_\_\_ Docs \_\_\_\_\_ Other \_\_\_\_\_

## QC:

Quarantine: Location: \_\_\_\_\_ Condition of Part: \_\_\_\_\_

Inspect: Initial: \_\_\_\_\_

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-667-203	30434				
1	D206-667-103	32139				

## QA Coordinator:

Advise GM as to findings: Initial: LD Date: 08/01/30

## Comments:

Not able to locate Product RAISE NCR 08-015.

NEED to credit Customer for items returned.

Re-worked with Primer Shield B32927.

Issue credit: yes no

QM Approval: [Signature]

Date: 08/01/30

Invoice Amount: \_\_\_\_\_  
 Less Replacement: \_\_\_\_\_  
 Restock Fee: \_\_\_\_\_  
 Freight: \_\_\_\_\_  
 Net Credit: 54,934.96  
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original.

Signed: \_\_\_\_\_ Date: \_\_\_\_\_

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit